Friday, 12/21/2007 7:27:47 AM Date: Kim Johnston ser: **Process Sheet** : DECAL **Drawing Name** : CU-DAR001 Dart Helicopters Services Customer Job Number : 36523 **Estimate Number** NIA : D32763 **Part Number** P.O. Number S.O. No. : NA D3276 REV B : 12/21/2007 **Drawing Number** This Issue : N/A Project Number Prsht Rev. : PURCHASED PARTS Type **Drawing Revision** First Issue : NA : 1/5/2008 : 36335 Material Previous Run Qty: 30 Um: Each **Due Date** Written By Checked & Approved By New issue KJ/JLM 05.02.14 Comment Additional Product Job Number: Description: Seq. #: Machine Or Operation: 1.0 PG **PURCHASING** Comment: PURCHASING CL07/12/21 Issue P/0: _5334 For D3276-3 decal as per Dwg D3276 Possible Supplier: Studio Lettrage Material release note is required D32763P Decal 2.0 Comment: Qty.: 1.0000 Each(s)/Unit Total: 30.0000 Each(s) Decal 3.0 PACKAGING RESOURCE #1 PACKAGING 1 Comment: PACKAGING RESOURCE #1 Recieive & Inspect for Transit Damage Ensure Material Release Note is attached 4.0 QC5 30 Comment: INSPECT WORK TO CURRENT STEP PACKAGING RESOURCE #1 5.0 Comment: PACKAGING RESOURCE #1 Identify and Stock 1/12/31 Location:

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	•	PAR #: Pault Category: NC	R: Yes	No DQA	: <u>A</u>	Date: <u>C</u>	8101/03
				N/C Closed			

NCR: WORK ORDER NON-CONFORMANCE (NCR)												
		Description of NC	Corrective Action Section B				Description of NC Corrective Action Section B				Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Chief Eng	QC Inspector				

NOTE: Date & initial all entries

Date:

Friday, 12/21/2007 7:27:47 AM

User:

Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DECAL

Part Number: D32763

Job Number: 36523

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

QC21

FINAL INSPECTION/W/O RELEASE





Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mi 2008/1/3 CZ

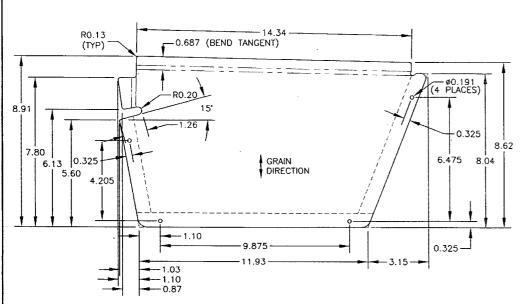
Dart Aerospace Ltd

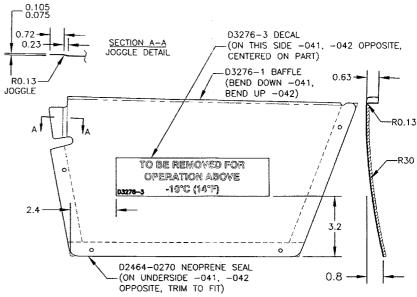
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QA: N/C Closed: ____ Date: _

NCR: WORK ORDER NON-CONFORMANCE (NCR)								
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DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspecto
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NOTE: Date & initial all entries



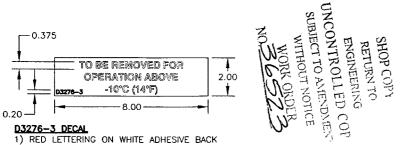


D3276-041 BAFFLE ASSEMBLY, LH (SHOWN)
D3276-042 BAFFLE ASSEMBLY, RH (BEND/JOGGLE OPPOSITE)

D3276-1 BAFFLE (FLAT PATTERN)

1) MACHINE PER DWG FILE "D3276-A.DWG"

- 2) MATERIAL: 6061-T6 ALUMINUM 0.040 THICK (QQ-A-250/11) (REF DART SPEC. M6061T6S.040)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



- 2) MANUFACTURE FROM 3M 7 MIL MASKING FILM #8522CP OR AVERY IPM #2031
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



	В	05.01.25	LABEL NOW -10	C; CURVE PART
	А	05.01.07	NEW. ISSUE	
IT @ 2004 SY DART AEROSPACE LID.	DESIGN CF	DRAWN BY	DART	DART AEROSPACE LTD.
CUMENT IS PRIVATE AND CONFIDENTIAL SUPPLIED ON THE EXPRESS CONDITION IS NOT TO BE USED FOR ANY PURPOSE	CHECKED	APPROVED	DRAWING NO. D3276	REV. E SHEET 1 OF
ED OR COMMUNICATED TO ANY OTHER WITHOUT WRITTEN PERMISSION FROM ROSPACE LTD.	05.01.25		BAFFLE ASSEMBLY	SCALI 1::



Purchase Order

Date Dec 21, 2007 Page

Purchase Order Number PO00005334

Dart Aerospace Ltd 1270 Aberdeen St

Hawksbury, Ontario K6A 1K7 (613)632-9577 Phone:

(613)632-1053 Fax:



CAD Dollars

492.90

Ship To:

Main Finished Goods Location Dart Aerospace Ltd

1270 Aberdeen St

Hawksbury, Ontario K6A 1K7

Vendor Address: Studio de Lettrage 2001 210 Main West Hawkesbury, ONT K6A 2H6 Canada (613) 632-5449 Phone 0 ⁻ax (613) 632-9491

	Contact	Vendor Number	PO Date	Terms	Ship Via	Expected Arrival
Reference	Contact	VC-STU001	Dec 21, 2007	N30	vours	Dec 05, 2007
	` <u> </u>	VC-310001	Dec 21, 2001	1	1	

Qty. Ordered	item Nu	mher	Des	scription		Expected Arrival	Drop- Ship	Unit Cost	MOU	Extended Price
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Approv∈ By:



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HAWKESE JRY, ONT. K6A 2H6

Tel.: 613 63 -5449 Fax: 613 63 :-9491

www.studic ettrage.on.ca

No.:

§9656

INVOICE / FACTURE

12/28/2007

DATE:

1 of 1

PAGE Re: Quote ... 4363

TOTAL

397.50

VENDU À: SOLD TO:

PO 5334

Sold By

Dart Aerospace Ltd 1270 Aberdeen

Hawkesbury, Ontario K6A 1K7

LIVRÉ À: SHIPPED TO:

Dart Aerospace Ltd

Hawkesbury, Ontario

	(fc 5334)			
ITEM QTY UNIT	DESCIPTION	GST PST TPS TVP	UNIT PRICE PRIX UNITE	AMOUNT MONTANT
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Product Bulletin 8522

3M

Release F, Effective January 2003 Black bar in margin indicates a change

Scotchcal [™] Opaque Imaging Media 8522

Description

This media is specially formulated to dry quickly after printing. Production of outdoor weatherable and long-term indoor durable graphics is now easier than ever. Its changeable adhesive allows easy removal for up to one year.

Advantages

- Optimized for use with selected Epson Stylus Proprinters and Epson Archival inks.
- Optimized for use with selected HP DesignJet Printers and HP DesignJet Ink System UV or HP83UV Color Ink System
- For making opaque, laminated graphics that are outdoor weatherable and long-term indoor durable
- Media:
 - For opaque (reflective) graphics
 - Changeable, easy to remove from warranted substrates up to 1 year later
 - Dries quickly after printing so the overlaminate can be applied almost immediately
 - Low slippage paper liner for superior tiling
- Overlaminates:
 - Provide additional UV (ultraviolet) and physical protection for making weatherable finished graphics
 - Available in luster and matte gloss
 - Adhesive allows for heat-assisted or cold-temperature lamination

Applications and Uses

3M Scotchcal Changeable Opaque Imaging Media 8522 is intended only for ink jet printing and for use with the listed Compatible Products and Equipment and the following applications. Any other application is NOT warranted by 3M or covered by the worldwide 3M MCS Warranty unless 3M gives its prior written approval for the application.

- First surface images (the image is on top of the film) for opaque posters and signs, including:
 - Graphics for vans, personal vehicles, trucks and buses
 - Novelty posters
 - Retail and point-of-purchase displays
 - Information graphics such as maps and directories
 - Entertainment promotions in museums, zoos, parks, theatres, sports venues
 - Education and presentation graphics

- Legal and courtroom exhibits
- For flat or simple curved surfaces, with or without rivets, used in vertical (± 10°) applications

Limitations of End Uses

The following uses and applications are specifically NOT warranted.

- Fleet applications in areas that use salt for winter road maintenance
- Application to non-warranted substrates, including wallboard
- Applications subjected to gasofine vapors or spills
- Application to corrugated or highly irregular surfaces or sharply raised areas
- Graphics applied to stainless steel, including stainless steel vehicles
- On flat surfaces with rivets, tenting of 4 to 10 mm around rivets may be expected; rivets may be cut around to eliminate tenting.

Note: Standard ink jet technology is water based. Waterbased chemistry is susceptible to the extremes of heat and humidity. This is a factor in most product constructions on the market. Read the Fabrication, Shelf Life and Storage sections in this bulletin. Staying in the middle of these ranges always provides optimum performance.

Compatible Products and Equipment

Thermal Ink Jet Printing Systems

- Epson Stylus Pro 9500, Stylus Pro 10000 printer
 - Epson Archival Inks
- Epson Stylus Pro 10600 printer
 - Epson Archival lnks
- HP DesignJet Printers 2000 and 3000 series
 - HP DesignJet Ink System UV (pigment-based ink)
- HP DesignJet Printers 5000 series
 - HP83UV Color Ink System

Overlaminates (required)

- 3M [™] Luster Overlaminate 8519 (semi-gloss)
- 3M[™] Matte Overlaminate 8520

Note: For the full product names of the 3M products listed on this page, please see page 1.

Warranted Substrates

Media 8522 is warranted for use on the following rigid substrates.

Some substrates may "out-gas", resulting in tiny bubbles throughout the surface of the graphic. For maximum performance, be sure the substrate you select is properly cleaned and prepared as recommended by the manufacturer. See Instruction Bulletin 5.1 for additional information.

- · Alodine (anodized aluminum)
- Automotive panels (automotive painted steel)
- Fruehauf (painted aluminum)
- FRP (fiberglass reinforced plywood)
- Glass
- Imron® (polyurethane-painted metal panel)
- Acrylic
- Sintra[™] board

Test and Approve Non-warranted Substrates Before Use

Media 8522 is not warranted for any substrate other than those listed above. If you want to use it for other substrates. 3M recommends that you test and approve the media for both adhesion and removal characteristics.

Characteristics

Characteristic	Description
Media	7 mil, white, opaque graphic film
Liner	Low-slippage, lay flat paper
Adhesive	Changeable, pressure sensitive
Thickness (media and adhesive)	7.5 to 8 mil (nominal)
Application substrates	See Warranted Substrates, above
Application surfaces	Flat or simple curved surfaces, with or without rivets, used in vertical (± 10°) applications (no corrugations)
Application temperature range	28° to 110°F (-2° to 43°C) (air and surface)
Roll sizes	36" x 45 feet (914 mm x 13.5 m) 54" x 45 feet (1372 mm x 13.5 m)

How to Become a 3M Ink Jet Registered Fabricator

Only 3M Thermal Ink Jet Registered Fabricators are eligible to offer 3M MCS warranted graphics. In order to become certified, a fabricator must complete the requirements as specified in the 3M Ink Jet Graphics Registered Fabricator Reference Manual located on the 3M website at www. scotchprint.com

Effective Performance Life

To obtain the warranty given below, the graphics must be made according to 3M's recommendations which are detailed in the Warranty and Limited Remedies on page 3. Also see the section, Removability.

Warranted Durability

Media 8522 with	Epson Pr	inters	HP Printers		
Overlaminate 8519 or 8520	Outdoor	Indoor	Outdoor	Indoor	
Applied to Warranted Substrates	2 years	5 years	3 years	5 years	

Removability

Imaging media 8522 is removable from warranted substrates for 1 year without the aid of chemical strippers or accessories. Refer to Instruction Bulletin 4.23 for additional information.

Fabrication

Graphics must be made according to 3M's recommendations which are detailed in the Warranty and Limited Remedies on page 3.

See Instruction Bulletin 4.23 for detailed fabrication, printing and mounting information.

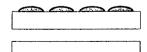
Graphic Construction Options

Opaque (Reflective) Graphics

Opaque graphics made with imaging media 8522 require an overlaminate and an opaque substrate.

Viewer/Light Source

Overlaminate 8519, 8520 Adhesive on bottom



Imaging Media 8522 Image on top; adhesive on bottom

Opaque Substrate

Note: For the full product names of the 3M products listed on this page, please see page 1.

Shelf Life and Storage

- 3M [∞] Scotchcal [∞] Changeable Opaque Imaging Media 8522 has a shelf life of one year.
- Storage conditions (new and partially used rolls). For optimum performance, use the middle of these ranges:
 - Original packaging, including plastic wrap
 - Relative humidity of 20% to 80%
 - Temperature of 33° to 104°F (0° to 40°C)
 - Away from direct sunlight
- Do not stack unprotected rolls or lay sharp or heavy objects on them.

Health and Safety

⚠ Caution

When handling any chemical products, read the manufacturers' container labels and the Material Safety Data Sheets (MSDS) for important health, safety and environmental information.

To obtain MSDS sheets for 3M products:

- By fax, call 1-800-364-0768 in the US and Canada or 1-650-556-8417 for all other locations.
- Electronically, visit us at http://www.3M.com/msds.
- By mail, or in case of an emergency, call 1-800-364-3577 or 1-651-737-6501.

When using any equipment, always follow the manufacturers' instructions for safe operation.

Warranty and Limited Remedies

3M MCS Warranty for Graphics Produced on HP DesignJet Printers and Epson Stylus Pro Printers

The following is made in lieu of all other express or implied warranties, including any implied warranty of merchantability or fitness for a particular purpose: We warrant graphics produced by a 3M Ink Jet Registered Fabricator made with imaging media 8522, printed on an approved HP thermal ink jet printer according to HP's recommendations or Epson Stylus Pro printer according to Epson's recommendations, overlaminated with 8519 or 8520, and applied to a Warranted Substrate according to 3M's recommendations. These

graphics are covered against failure caused by ultraviolet light, temperature extremes, pollution, and other elements.

If a graphic fails to perform in accordance with 3M product specifications within this time frame, 3M will replace the materials at no charge. These remedies are exclusive. In no case shall 3M be liable for any direct, indirect, or consequential damages, including any labor charges.

3M Related Literature

Listed below is related 3M technical literature that may be of interest. You may view and print these Bulletins from our Web site at www.scotchprint.com, or order them via our Faxon-Demand (FOD) system. Call one of these phone numbers to order the desired bulletins, and specify the FOD document number provided in the chart.

United States or Canada: 1-800-364-0768

International: 1-651-732-6506

Subject	Bulletin No.	FOD No.						
Product Bulletins								
3M [™] Scotchcal [™] Overlaminate 8519 and 8520	8519/8520	4524						
Instruction Bulletins								
Making thermal ink jet graphics	4.23	6523						
Application, substrate selection, preparation and substrate-specific application techniques	5.1	7001						
Warranties								
Worldwide 3M ** MCS ** Warranty Packet (includes all Commercial Graphics MCS Wa	s t rranties)	9503						
Worldwide 3M MCS™ Warranty Overv		9504						

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Bulletin Change Summary

The Epson Stylus Pro Printers 9500, 10000 10600, and Epson Archival Inks have been added to this bulletin. Additional changes resulting from this addition are marked with black bars in the margin.

3M

Commercial Graphics Division

3M Center, Building 220-6W-06 PO Box 33220 St. Paul, MN 55133-3220 USA General Info. 1-800-374-6772 Technical Info. 1-800-328-3908 3M Canada

P.O. Box 5757 London, Ontario Canada N6A 4T1 1-800-265-1840 Fax 519-452-6245 3M México, S.A. de C.V.

Av. Santa Fe No. 55 Col. Santa Fe, Del. Alvaro Obregón México, D.F. 01210 52-55-52-70-04-00 Fax 52-55-52-70-22-77 3M Puerto Rico, Inc.

Puerto Rico Industrial Park P.O. Box 100 Carolina, PR 00986-0100 787-620-3000 Fax 787-750-3035

Fax 1-651-736-4233
Fax on-Demand 1-800-364-0768 US/Canada or 1-651-732-6506 International Fax-on-Demand document: 4506 www.scotchprint.com

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